

Work Order ID 163562

Wednesday, June 28, 2017 3:39:02 PM

163562

Page 1

Item ID: D4941-4L08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector, Aft RH, (Clear)

Start Date: 7/5/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/12/2017 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: 

Date:

JUN 28 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4941	D

110

0.00

110

THERMOFORMING MACHINE

Purchasing

Memo

0.00

Purchasing

ISSUE P/O:

37041

SUPPLIER:PLASTECH

MANUFACTURE D4941-4L08 AS PER DWG

C OF C IS REQUIRED

DAS
13
9-89

JJB 17/07/13

140

0.00

140

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Packaging

Memo

0.00

Packaging

5x Sp A-9-12.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Accept

N900040100

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC6- All purchased or subcontracted products

0.00

150

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE JUL 11 2017

RELEASED PD

DATE 17-09-20

⑤ 17-09-20 PA.

170

Identify as per dwg & Stock Location: ST

0.00

170

Packaging

Memo

0.00

Packaging

J SEP 20 2017

DAS
6
9-29

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

17/9/21 JF

WY 17/9/20

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Wednesday, June 28, 2017 3:39:02 PM

Page 1

Work Order ID: 163562

163562

Parent Item: D4941-4L08

D4941-4I 08

Parent Item Name: Floor Protector, Aft RH, (Clear)

Start Date: 7/5/2017

Required Date: 7/12/2017

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev A New Issue 13/12/16 DL

IPP Rev. B

Revised dimensions 14/02/12 DL

IPP Rev C revised Dwg.

14/07/02 DL

IPP Rev. D Revised Dwg. 14/07/25

DL

IPP Rev.E 17.06.13 Now outside process DP

Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-4L08P		Purchased	No			110	Each	0.0000	1	5			
D4941-4I 08P									**				
Floor Protector, Aft RH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	24.375		SEP 21 2017	
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				RM		194.56897							
				m126994		194.56897							

DQA: _____ Date: _____

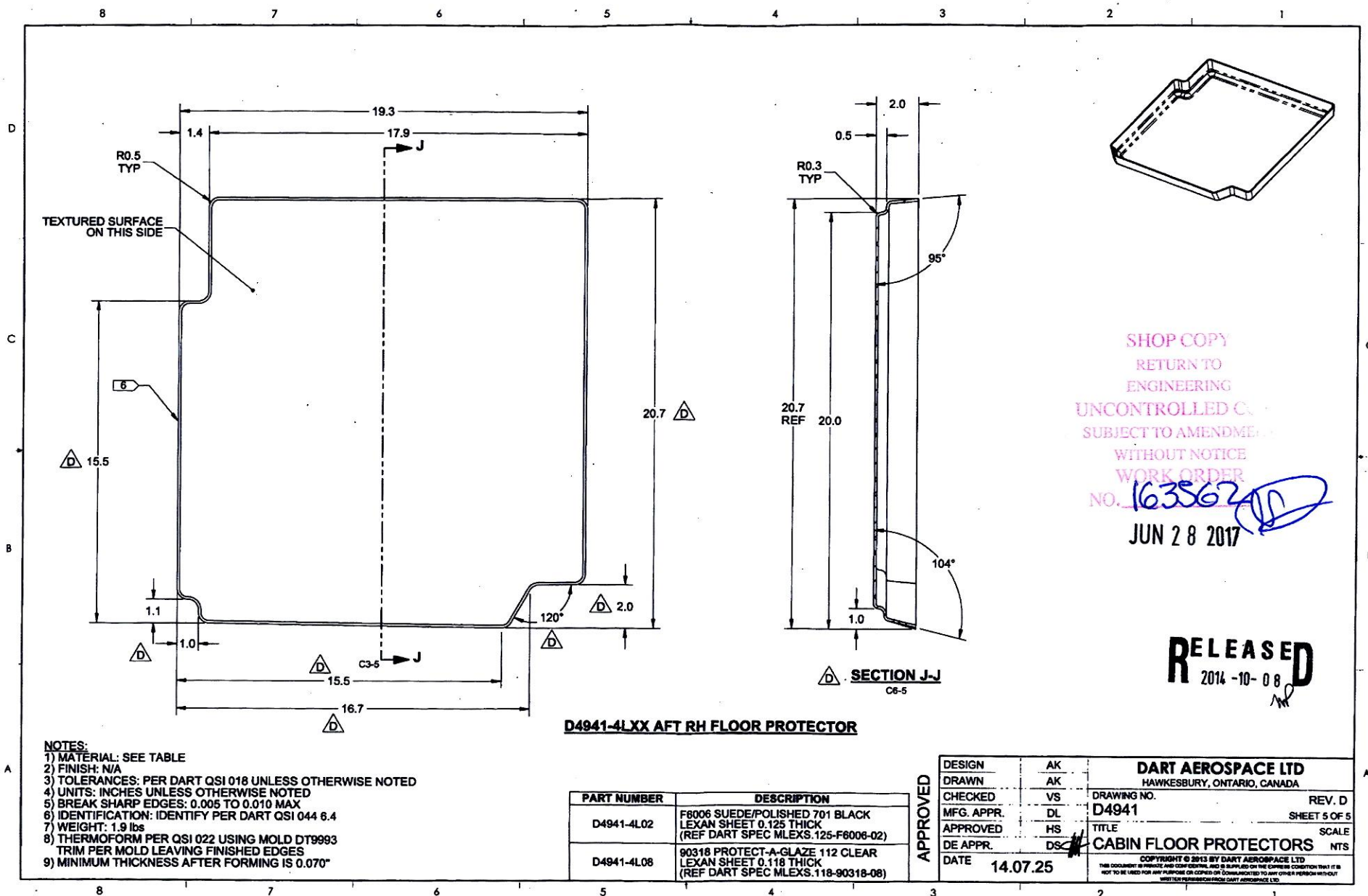


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER
Purchase Order ID PO37041

Purchase Order Date 7/13/2017
PO Print Date 7/14/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D4941-3L08P	Floor Protector, Aft LH, (Clear)	8/3/2017	5.00	\$65.00	\$325.00
			Yes	Each		
			8/3/2017			

As per dwg D4941
REV. D
B163559

Line Total: **\$325.00**

4	D4941-4L08P	Floor Protector, Aft RH, (Clear)	8/3/2017	5.00	\$65.00	\$325.00
			Yes	Each		
			8/3/2017			

As per dwg D4941
REV. D
B163562

Line Total: **\$325.00**

Note:

7/14/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P: 416 736 0004
F: 416 736 0010

Shipment Number: 24292
Shipment Date: 09/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B I L L T O
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CA
Attn: ROBERT ABOUD
Buyer Contact: ROBERT ABOUD

S H I P T O
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CA
Attn: ROBERT ABOUD

Purchase Order
37041
Carrier Account #

Sales Order
SO-019295

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number

Ship Via
FREIGHTCOM INC. -

Item Number - Revision	Description	HS Code	Country of Origin
D4941-1L08 - Rev.: D	CABIN FLOOR PROTECTORS	3920.61.1000 - OTHER	CA
D4941-2L08 - Rev.: D	CABIN FLOOR PROTECTORS	3920.61.1000 - OTHER	CA
D4941-3L08 - Rev.: D	CABIN FLOOR PROTECTORS	3920.61.1000 - OTHER	CA
D4941-4L08 - Rev.: D	CABIN FLOOR PROTECTORS	3920.61.1000 - OTHER	CA

Quantity Shipped UOM

5 EA

5 EA

5 EA

5 EA

SP17-9-12

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37041 SO # 019295

Part #	<u>D4941-1L08</u>	Qty.	<u>5</u>	Batch #	<u>-001</u>
Description					
	<u>CABIN FLOOR PROTECTORS</u>		<u>1 SHEET</u>		<u>M138294</u>
Part #	<u>D4941-2L08</u>	Qty.	<u>5</u>	Batch #	<u>-002</u>
Description					
	<u>CABIN FLOOR PROTECTORS</u>		<u>1 SHEET</u>		<u>M138294</u>
Part #	<u>D4941-3L08</u>	Qty.	<u>5</u>	Batch #	<u>-003</u>
Description					
	<u>CABIN FLOOR PROTECTORS</u>		<u>1 SHEET</u>		<u>M138294</u>
Part #	<u>D4941-4L08</u>	Qty.	<u>5</u>	Batch #	<u>-004</u>
Description					
	<u>CABIN FLOOR PROTECTORS</u>		<u>1 SHEET</u>		<u>M138294</u>
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 C OF C # 011
(Approved QA Signatory)

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, RH Aft		Part Number:	D4941-4L02/L08
Inspection Dwg: D4941	Rev: D	Page 1 of 1	

INSPECTION SHEET THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date:	17/09/14
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.3	+/-0.100	19.3"	✓			
17.9	+/-0.100	17.9"	✓			
20.7	+/-0.100	20.6"	✓			
2.0	+/-0.100	2.0"	✓			
16.7	+/-0.100	16.7"	✓			
15.5	+/-0.100	15.5"	✓			
1.1	+/-0.100	1.1"	✓			
2.0	+/-0.100	2.03"	✓			
0.070	Min	0.088"	✓			

Measured by:	DAS 07 9-89	Checked by:	PD	QC Inspector:	
Date:	17/09/14	Date:	17.09.20	Date:	17/09/14

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	
B	15.04.27	Dimensions updated per Dwg Rev D	KJ	
C	16.06.24	Dwg Rev updated	KJ	

Inspection Checklist

COPY

PLAS-TECH
Think Plastics™

Customer: Dart Aerospace Ltd

SO # 019295-004

Description: Floor Protector, RH Aft

Part #: D4941-4L02/L08

Inspection Dwg: D4941

Rev: D

Page: 1 of 1

Inspection Checklist:

☐

First Article

☐

Prototype

☒

First Off

Thermoforming Section

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratches	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Trimming Section

Drawing Dim.	Tolerance	Actual Dimensions	Accept	Reject	Method of Inspection	Comments
19.3	+/- 0.100	19.3	✓			
17.9	+/- 0.100	17.85	✓			
20.7	+/- 0.100	20.7	✓			
2.0	+/- 0.100	1.94	✓			
16.7	+/- 0.100	16.7	✓			
15.5	+/- 0.100	15.5	✓			
1.1	+/- 0.100	1.1	✓			
2.0	+/- 0.100	1.93	✓			
0.070	Min	N/A				

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Approval by: _____

Date: _____

Rev.	Date	Change	Revised by	Approved